

533

| | |
|---|-------------------------------|
| DART AEROSPACE LTD | Work Order: - 24072 |
| Description: Custom W/O to correct welding Jig | Part Number: D3379-041 |
| Dwg: D3379 Rev. C page 1 | |
| Ref: N/A | Page 1 of 1 |

| Step | Location | Procedure | By | Date | Qty | | | | | | | | | | | | |
|------|-------------|---|--------|-------------|-------------|-------|---|-----------|--------------|--------|--|--|--|--------|--|--|--|
| 1 | DC | Issue Traveler | HT | 05.08.15 | 1 | | | | | | | | | | | | |
| 2 | ST | Remove D3379-041 Arm Weldment from store. B22468A <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3379-041</td> <td>Arm Weldment</td> <td>B22470</td> </tr> <tr> <td></td> <td></td> <td></td> <td>B22624</td> </tr> </tbody> </table> | Qty | Part Number | Description | Batch | 1 | D3379-041 | Arm Weldment | B22470 | | | | B22624 | | | |
| Qty | Part Number | Description | Batch | | | | | | | | | | | | | | |
| 1 | D3379-041 | Arm Weldment | B22470 | | | | | | | | | | | | | | |
| | | | B22624 | | | | | | | | | | | | | | |
| 3 | MFA | Rework the weld by correcting the position of D3379-1 support as per Dwg D3379 | SPL | 06.01.25 | 1 | | | | | | | | | | | | |
| 4 | QC5 | Inspect work to Step 3 and jig. | SPL | 06.01.25 | 1 | | | | | | | | | | | | |
| 6 | FP | Powder Coat Fire Red (Ref. 4.3.5.10) as per QSI 005 4.3 | | | | | | | | | | | | | | | |
| 7 | QC3 | Inspect Powder Coat | | | | | | | | | | | | | | | |
| 8 | ST | Identify and Stock D3379-041 as per step 2 Return to stock | | | | | | | | | | | | | | | |
| 9 | AC | Charge to project number P601-571/-572 Cost / part: _____ | | | | | | | | | | | | | | | |
| 10 | DC | Close W/O Inspect Level 21 | | | | | | | | | | | | | | | |

(Note: Attach a copy of Custom W/O to each of the W/O's listed in Step 2 above)

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|----------|
| A | 05.08.15 | New Issue | KJ/RF | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

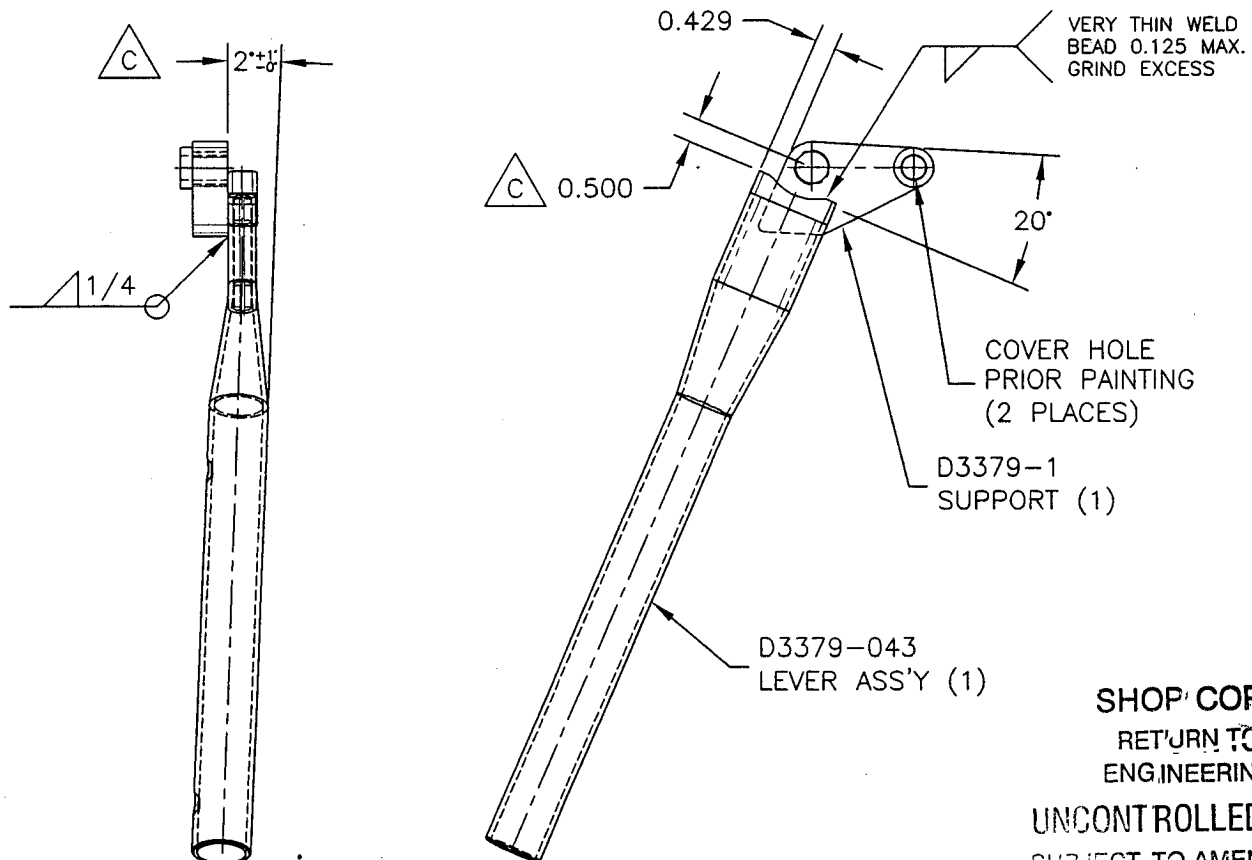
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



| | | | |
|------------------|---------------|---|------------------------|
| DESIGN 3 | DRAWN BY H | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED 3 | APPROVED H | DRAWING NO. D3379 | REV. C SHEET 1 OF 4 |
| DATE 05.05.27 | | TITLE ARM WELDMENT | SCALE 1:1 |
| A | 04.12.13 | NEW ISSUE | |
| B | 05.02.25 | RE-DESIGN D3379-5 | |
| C | 05.05.27 | 2" WAS 4"; UPDATE DIMENSIONS | |

RELEASED
11/5
05/01/05



D3379-041 ARM WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3379-041T1
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT FIRE RED (REF 4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 24072

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:50 am

Work Order No : 0024072
Project Name : D3379-041
Project For : WK533
Work Order Type : Main
Main WO Number :
House Part Number : D3379-041
Description : Arm Weldment
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 08-15-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | 0.00 | 10.25 | 100.00 | | |
| Production Cost | 0.00 | 164.72 | 100.00 | 0.00 | 164.72 |
| Packaging Hours | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours | 0.00 | 0.00 | 0.00 | | |
| CNC | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | 0.00 | 0.00 | 0.00 | | |
| Misc. | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden | 0.00 | 0.00 | 0.00 | | |
| Total Cost | 0.00 | 164.72 | 100.00 | | |
| Margin | 0.000 | 0.000 | | | |
| Selling Cost | 0.00 | 164.72 | | | |

| | Estimated | Actual |
|------------------------|-----------|------------|
| Labour Hrs/Amount Done | 0.00 | 0.00 |
| Profits/(Loss) | 0.00 | (-164.72) |

MIS 01/13
u
11-13

Date: Monday, 14/11/2005 8:34:42 AM
 User: Alba Panzuto

Process Sheet

| | | | |
|------------------------------------|-------------------------------------|---------------------------|--------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | ARM WELDMENT |
| Job Number : | 24072 | | |
| Estimate Number : | 10450 | | |
| P.O. Number : | | Part Number : | D3379041 |
| This Issue : | 14/11/2005 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D3379 REV C |
| First Issue : | / / | Project Number : | |
| Previous Run : | 23640 | Drawing Revision : | C |
| | Type : | Material : | |
| | LARGE FAB ASSY | Due Date : | 30/11/2005 |
| Written By : | | Qty: | 1 |
| Checked & Approved By : | | Um: | Each |
| Comment : | Est A 05.02.03 New issue KJ/JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------|----------------|
| 1.0 | D3379043 | Lever Assembly |
|-----|----------|----------------|

| | | |
|-----|--------|---------|
| 2.0 | D33791 | Support |
|-----|--------|---------|

| | | |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1
 Assemble and weld using welding Jig DT8764 as per Dwg D3379
 Identify as D3379-041

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

| | | |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING
 Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3
 Mask holes

| | | |
|-----|-----|---|
| 6.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

| | | |
|-----|-------------|-----------------------|
| 7.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

Date: Monday, 14/11/2005 8:34:42 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM WELDMENT

Job Number: 24072

Part Number: D3379041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

